

Date: Thursday, 3/23/2006 3:44:37 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 26350		
Estimate Number	: 10288		
P.O. Number	: N/A	Part Number	: D25771
This Issue	: 3/23/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2577 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25137	Drawing Revision	: E
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW.</u>	Due Date	: 4/15/2006
Checked & Approved By	: <u>06.03.24</u>	Qty:	50 Um: Each
Comment	: Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/ RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 0000892

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-101

Material release note required

2.0	D25771F	Wearplate Fwd
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

WEAR PLATE FWD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-101T

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/23/2006 3:44:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26350

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Form joggle as per Dwg D2577 using DT8157

3-Identify as D2577-1

FF 06.04.20

50

FF 06.04.20

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M100452

H.M 06-04-27

PTD

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION .

06/05/02 (50)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/05/03 (50)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 05 03 (50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DC 06/05/03 (50)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

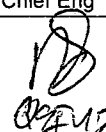
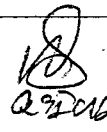
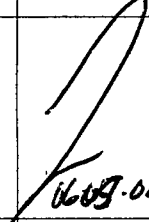
Inspection Level 21

06/05/04 (50)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-02	8	13 warp plates need to be re-melted. Handcast didn't penetrate enough into the warp plate. Lack of heat on the torch.		PASS the torch over the strikers, and re-apply hand cast as necessary. AS per QSI 1104	M.F. 06.05.02	AA 06/05/02		

NOTE: Date & initial all entries

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
00.04.26

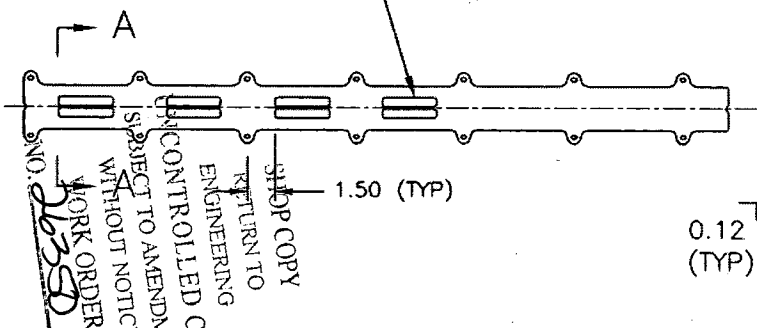
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 1 OF 5
A	NEW ISSUE	SCALE
B	ADD HARDCOAT WELDS	1:10
C	CHANGE HOLES TO OBROUNDS	
D	CORRECTED DIMENSIONS ON -1 & -3	
E	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

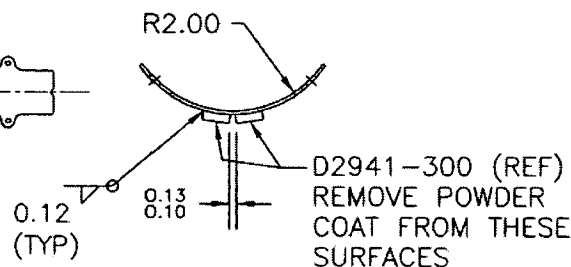


D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



SECTION A-A  
SCALE 1:5

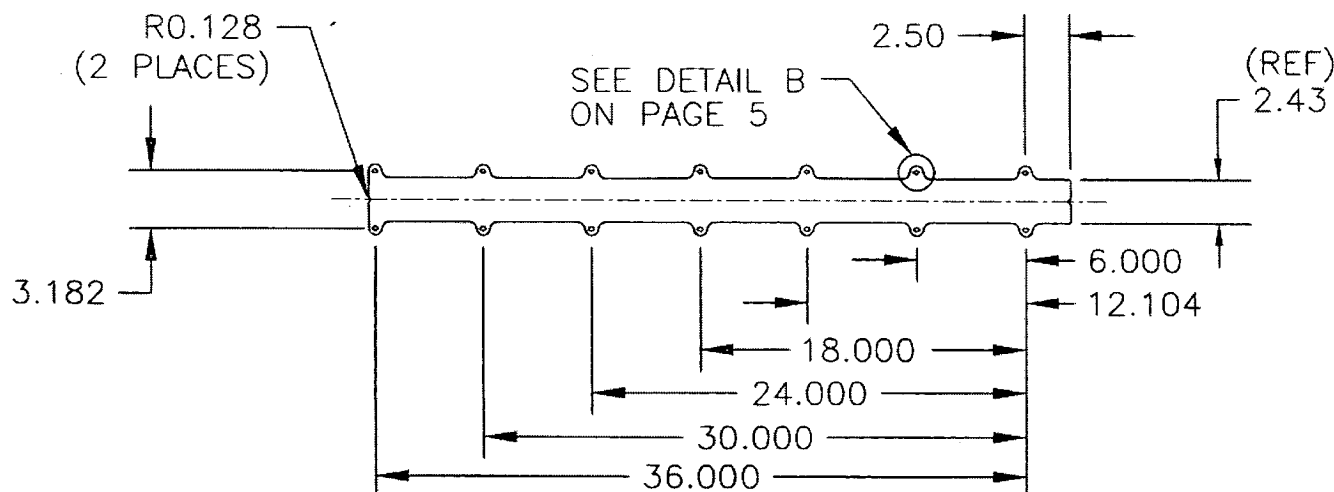


D2577-1 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
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<i>[Signature]</i>	<i>[Signature]</i>	D2577	SHEET 2 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10

00-0926-4

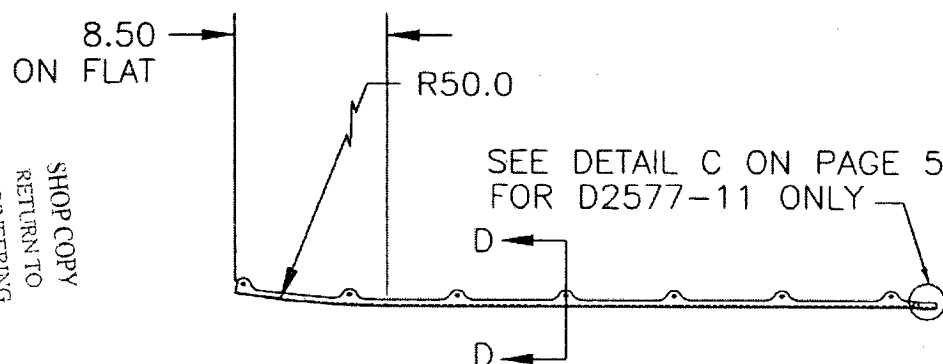


BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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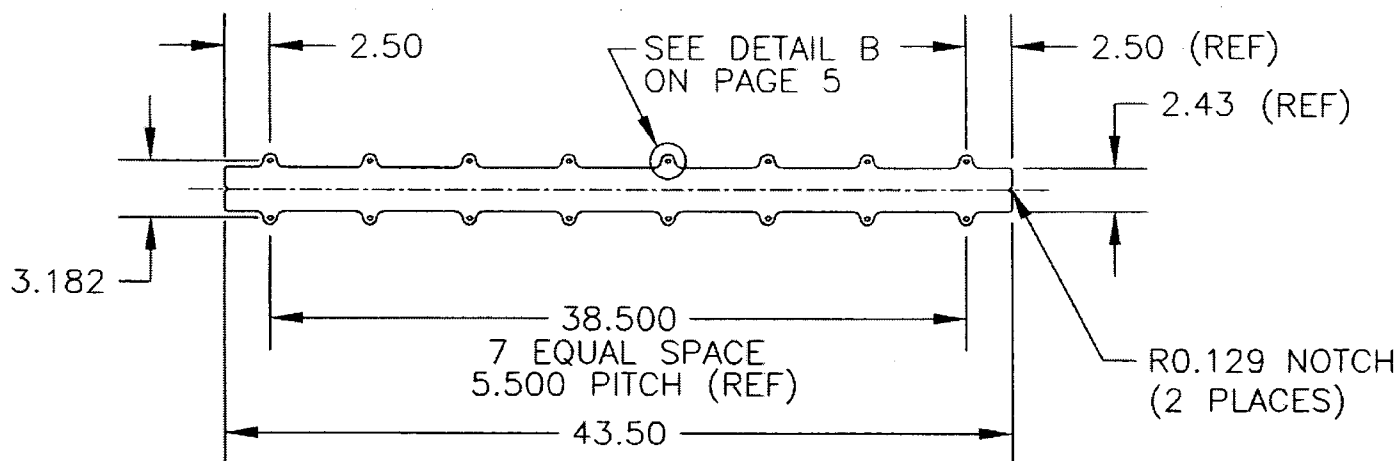
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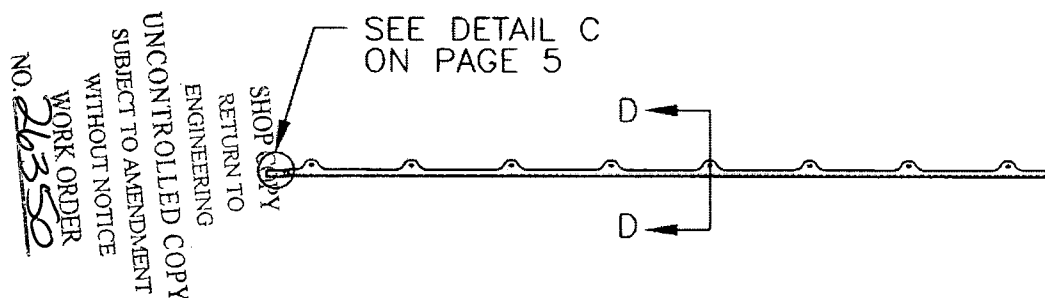
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00.09.22	D2577	SHEET 3 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

RELEASED  
00.09.26

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

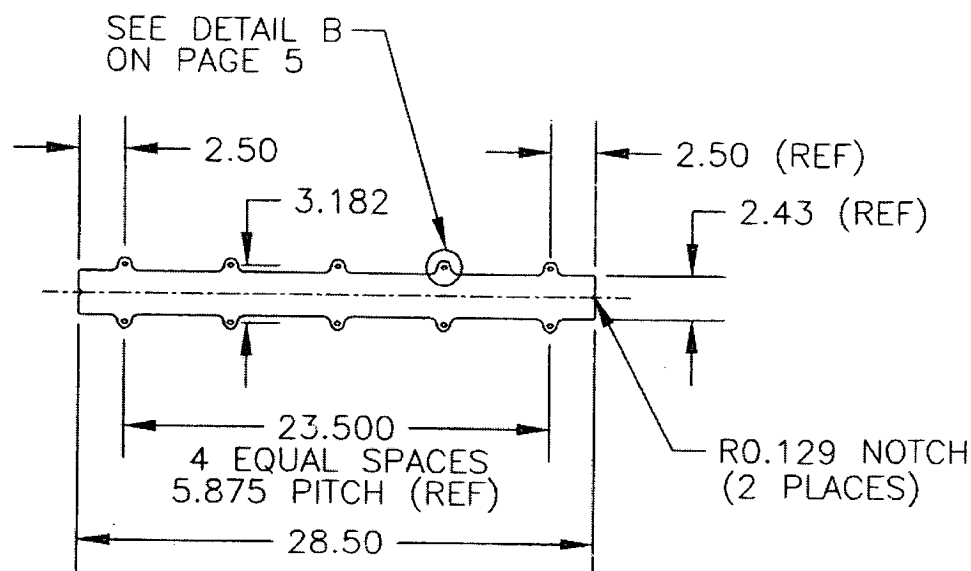




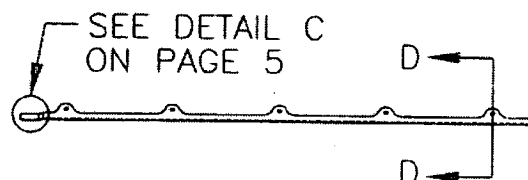
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DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 4 OF 5 SCALE 1:10

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00.09.26

### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

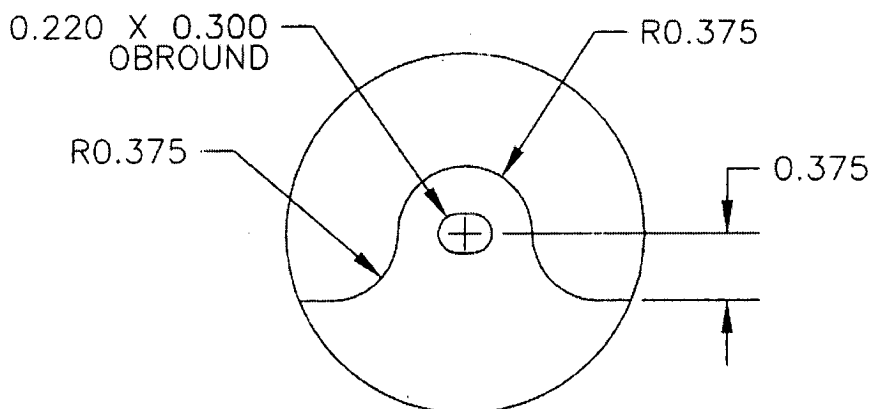
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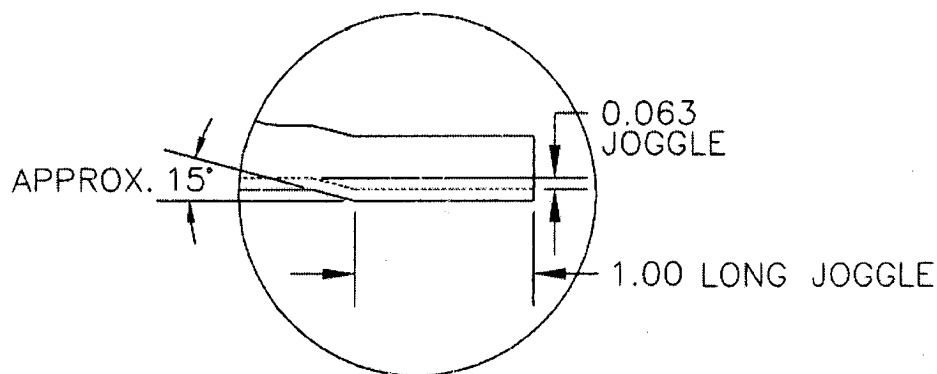
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

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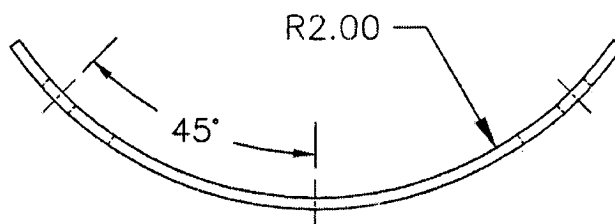
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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Feb. 1991 373

## TEST CERTIFICATE

01:50772917

CUSTOMER		Widmann		P505050T002		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		T0115188	
CUSTOMER D/W		90-124-T42				PRODUCT		CRA WIDE COIL		PAGE		1 of 1	
MILL D/W		408546				DIMENSIONS		60.3" x 49" x Cold		DATE		02 August 2005	

YIELD STRESS	GUAGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	EXPANSION TEST	CARBON EQUIVALENT VALUE (CE)
(A) 0.2% PROOF STRESS	(A) 200mm (C) 80mm (E) 2	(A) 0 (C) 48 (E) 50	(A) 10mm x 50mm (C) 2.5mm x 10mm (E) 5mm x 10mm	(A) C <sub>Mn</sub> /8 (C) C <sub>Mn</sub> /6 + C <sub>Cr</sub> /15 (E) C <sub>Mn</sub> /6 + C <sub>Cr</sub> /15
(B) FLOWER YIELD STRESS	(B) 80mm (D) 3.5 : 50 (F) 8	(B) 50 (D) 50 + 50 + 2.5 : 14		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

**APPROVED**

DCMETHALLITE

50377-00007-3 T M INDEPENDENT (P505057102.844863)

04/18/2006 10:46 FAX 604 946 4153

## INDUSTRIAL LASER CUTTING → DART

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